

20-7874



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 205051



Part No: 646.9711

Job Qty: 30 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		3/30/20	0.00	0.93	Bandsaw - 1		
110	HAAS 4 Axis - B4B	30 pcs		3/30/20	0.13	12.50	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	30 pcs		3/30/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S248456



Part: 646.9711

Job No: 205051

Serial No/Batch: S248456

Revision: Rev H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/17/20

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	30 pcs	3/30/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				MEI001-VC	15
140 Outsource - 1 - Heat Treat	30 pcs	3/30/20			
150 Packaging 2-1 - Receive - B4B	30 pcs	3/30/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 -	

20/01/28

2020-01-29

FEB 04 2020

				B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	30 pcs	3/30/20	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	FEB 04 2020 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	DAS
160 Spray Paint - 2 - B4B	30 pcs	3/30/20	0.00 1.00	Spray Paint - 1 - B4B	41 FEB 05 2020
				Spray Paint - 2 - B4B	9-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
170 QC 14	30 pcs	3/30/20	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	DAS
				QC 14 - 40	FEB 05 2020 40
				QC 14 - 19	9-89

				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
185	Packaging 3-1 - Stock - B4B	30	3/30/20	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 -

				B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	30 pcs	3/30/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	548 FEB 06 2020
				QC 21 - SA - 53	21

Part Op 100 - (Bandsaw) Cut Blank at 4.625"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB135
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS
 PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 160 - (Spray Paint / NDT Room) ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4 5236137
 170 - (QC14- Inspect Spray Paint)
 185 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

FEB 06 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	11.5800 ft (.386 ea)	100-Bandsaw - 1	3232 654 5242150

Job Allocations

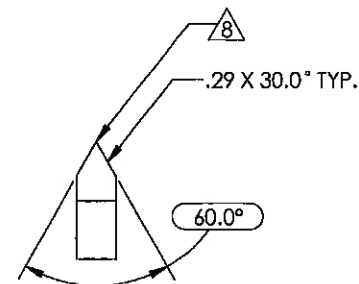
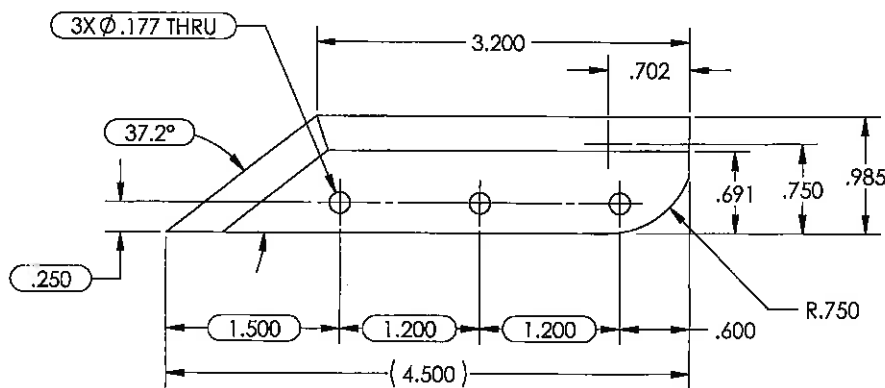
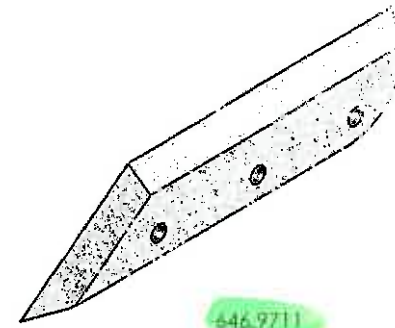
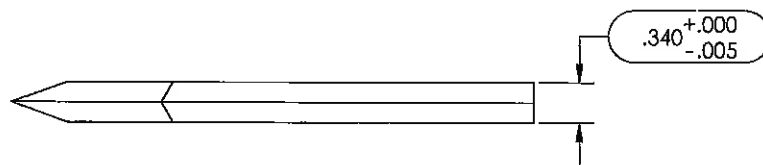
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	12	92	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.340Inches + 0.000 - 0.005	0.340 0.335		338
2	Blade	0.177Inches + 0.005 - 0.001	0.182 0.176		.177
3	Blade	3.200Inches ± 0.005	3.205 3.195		3.200
4	Blade	0.600Inches ± 0.005	0.605 0.595		0.600
5	Blade	0.985Inches ± 0.005	0.990 0.980		.984
6	Blade	2.400Inches ± 0.005	2.405 2.395		2.400
7	Blade	1.200Inches ± 0.005	1.205 1.195		1.200
8	Blade	0.250Inches ± 0.005	0.255 0.245		.250
9	Blade	37.2Angle ± 0.5	37.7 36.7		37.5
10	Blade	0.290Inches ± 0.010	0.300 0.280		.286
11	Blade	30.0Angle ± 0.5	30.5 29.5		30.0

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646.9711

DESIGN: LBS	DATE: 10/10/00	DART 3000 ENTERPRISE CT. VISTA, CA 92081 (760) 754-6100 FAX: (760) 754-6101 WWW.DARTINDUSTRIES.COM
APPROVED: J. BROWN	DATE: 10/10/00	
DESIGNED: J. BROWN	DATE: 10/10/00	
CHECKED: J. BROWN	DATE: 10/10/00	
TITLES OF DRAWING (INCLUDE) 1. CUTTER SUB ASSEMBLY 2. CUTTER SUB ASSEMBLY 3. CUTTER SUB ASSEMBLY 4. CUTTER SUB ASSEMBLY 5. CUTTER SUB ASSEMBLY 6. CUTTER SUB ASSEMBLY 7. CUTTER SUB ASSEMBLY 8. CUTTER SUB ASSEMBLY 9. CUTTER SUB ASSEMBLY 10. CUTTER SUB ASSEMBLY		SHEET CODE: 646.9700 SCALE: N/A SHEET: 1 OF 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045724**



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045724

PO Date: 1/29/20

Due Date: 2/14/20

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

2020-01-30

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203834	646.3315	646.3300 Rev A	Blade : Various STC's HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	2/14/20	30 pcs	0 pcs	30 pcs	\$2,1202/pcs	\$63.61

FEB 04 2020



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PURCHASE ORDER

POHB045724



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	203833	646.3314	646.3300 Rev A	Blade : Various STC's HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed X30	-	2/14/20	30 pcs	0 pcs	30 pcs	\$2.1202/pcs	\$63.61
FEB 04 2020												
3	205051	646.9711	646.9700 Rev H	Blade : Various STC's (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed X68	-	2/14/20	68 pcs	0 pcs	68 pcs	\$2.1202/pcs	\$144.17
FEB 04 2020												

DAS
68
9-89



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045724



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	203835	646.3316	646.3300 Rev A	Blade Various STC's HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed -		2/14/20	30 pcs	0 pcs	30 pcs	\$2.1202/pcs	\$63.61
											Grand Total:	\$334.99

FEB 04 2020

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Handwritten signature: H. Guerin

Plex 1/30/20 4:50 PM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
342581	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB045724	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	13 (907)	59 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
158	48	646.3315 ✓ (30) 646.3315 REV A JOB 203834 (30) 646.3314 REV A ✓ JOB 203833 (68) 646.9711 REV H ✓ JOB 205051 (30) 646.3316 REV A ✓ JOB 203835 3 = 1 SAC + 1 BC		

RECEIVED
FEB 03 2020
DART AEROSPACE LTD.

COMMENTAIRES / comments

VAC HARDEN 1800°F - 1:00 HRE
DOUBLE TEMPER 400°F - 1:00 HRE

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

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342581	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué; échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

DATE: 2020-02-03

Lucie Desmarais
QA Technician



